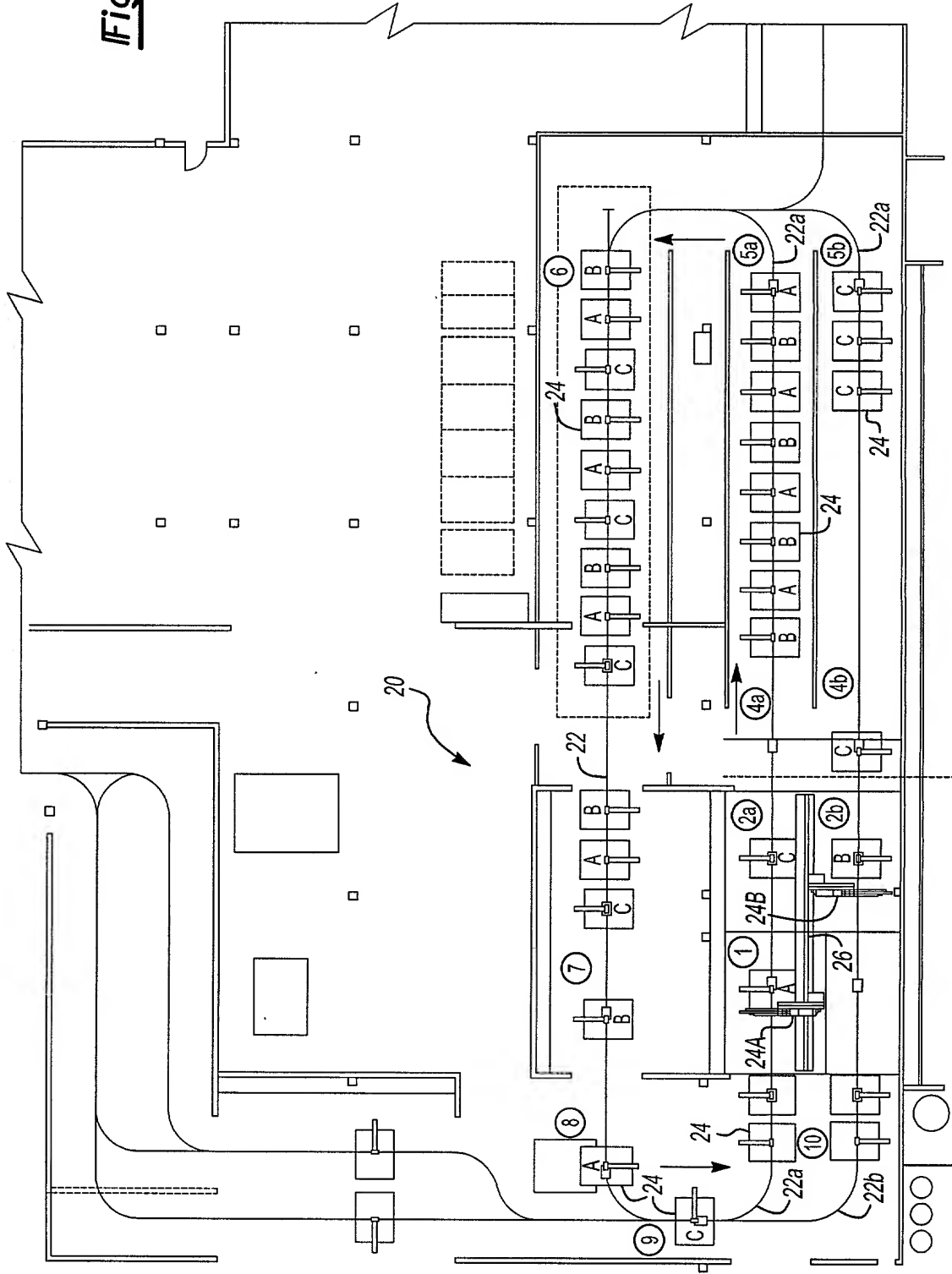


Fig-1



Inside Spray Booth

Outside Spray Booth

	Zone 1	Zone 2	Lap	Zone 4	Zone 5a/5b	Zone 6	Zone 7	Zone 8	Zone 9	Zone 10
Mold Lap	Gelcoat		To lap B	Queue (4a)	Cure	Cure/ Queue	No stop req'd.	De-mold finished "c" lap part -- one minute.		Wipe -- two min total
Lap 1 "A"				Queue (4b) Roll; Trim	Cure	Cure/ Queue	Rotate; Flip and Chop; Barrier Coat -- two min. total.	No stop req'd.	No stop req'd.	No stop req'd.
Lap 2 "B"		First Chop Coat Spray	To lap C	Queue (4a)	Cure	Cure/ Queue	Foam; Base; Rotate -- one min. total	No stop req'd.	No stop req'd.	No stop req'd.
Lap 1 "C"		Cover Coat Spray	To lap A							

2/5

Fig-2

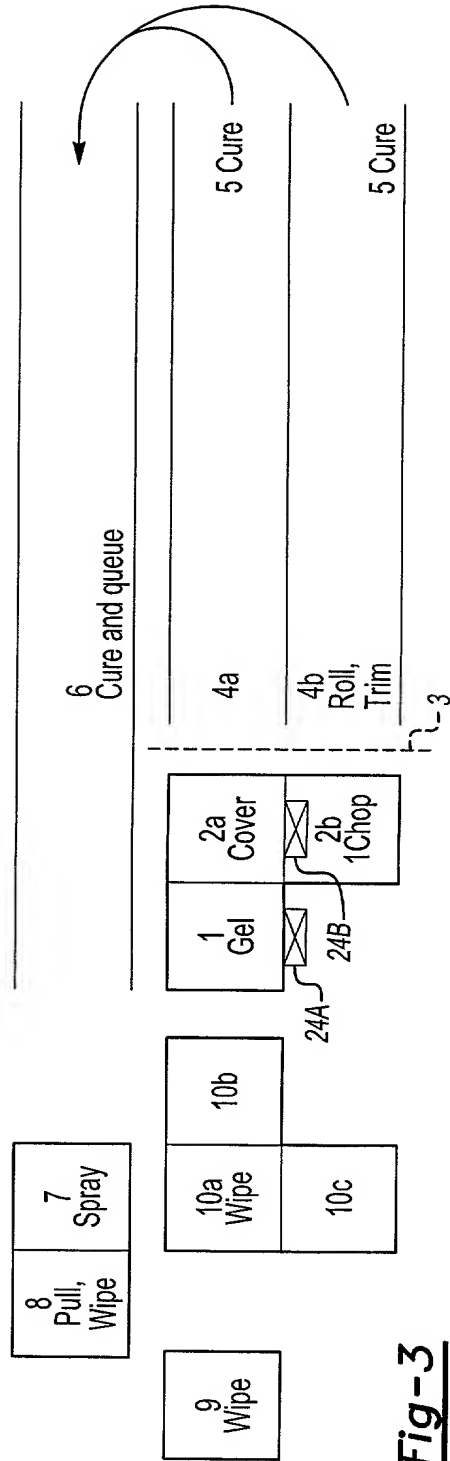


Fig-3

Fig-4A

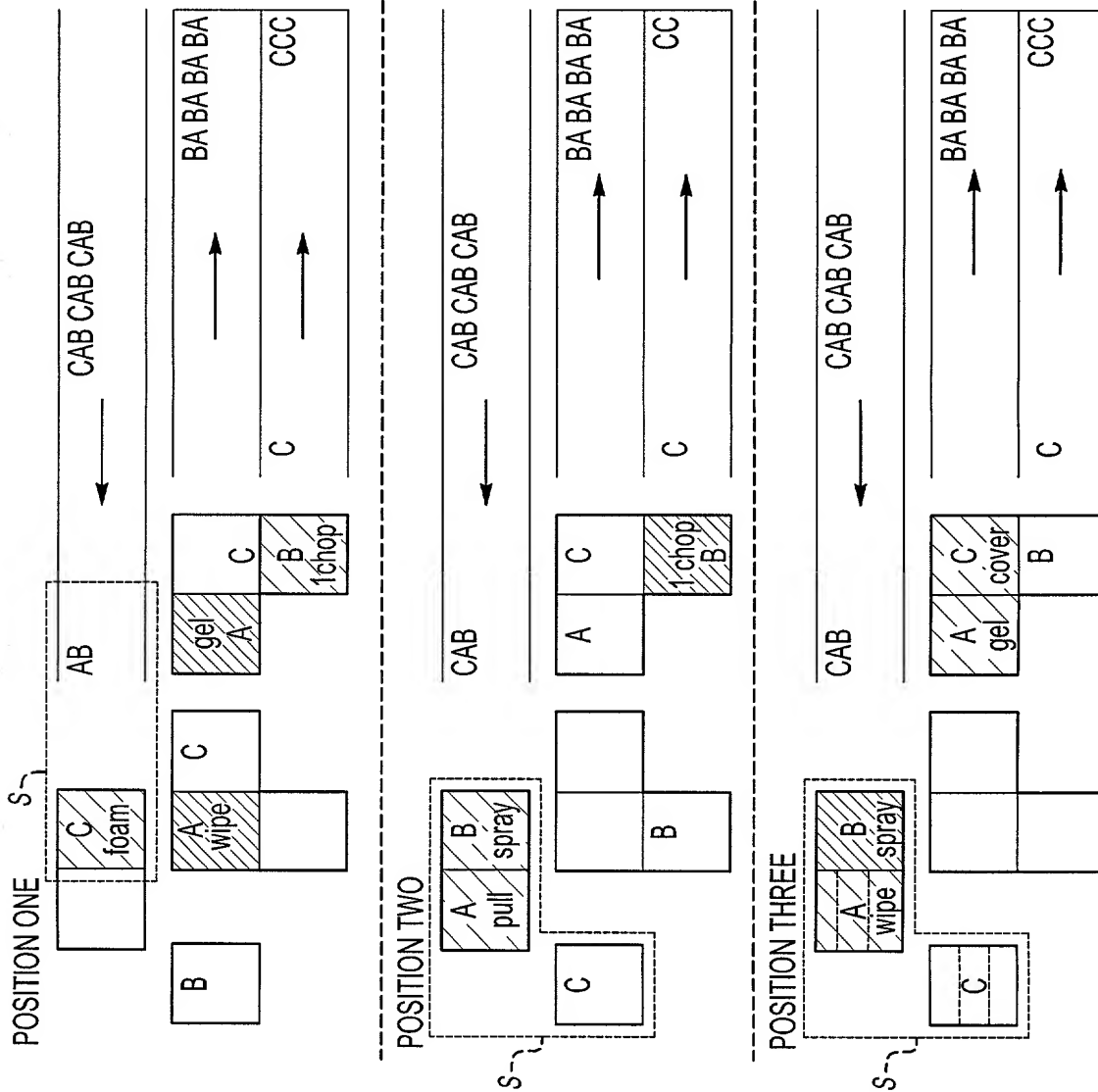


Fig-4B

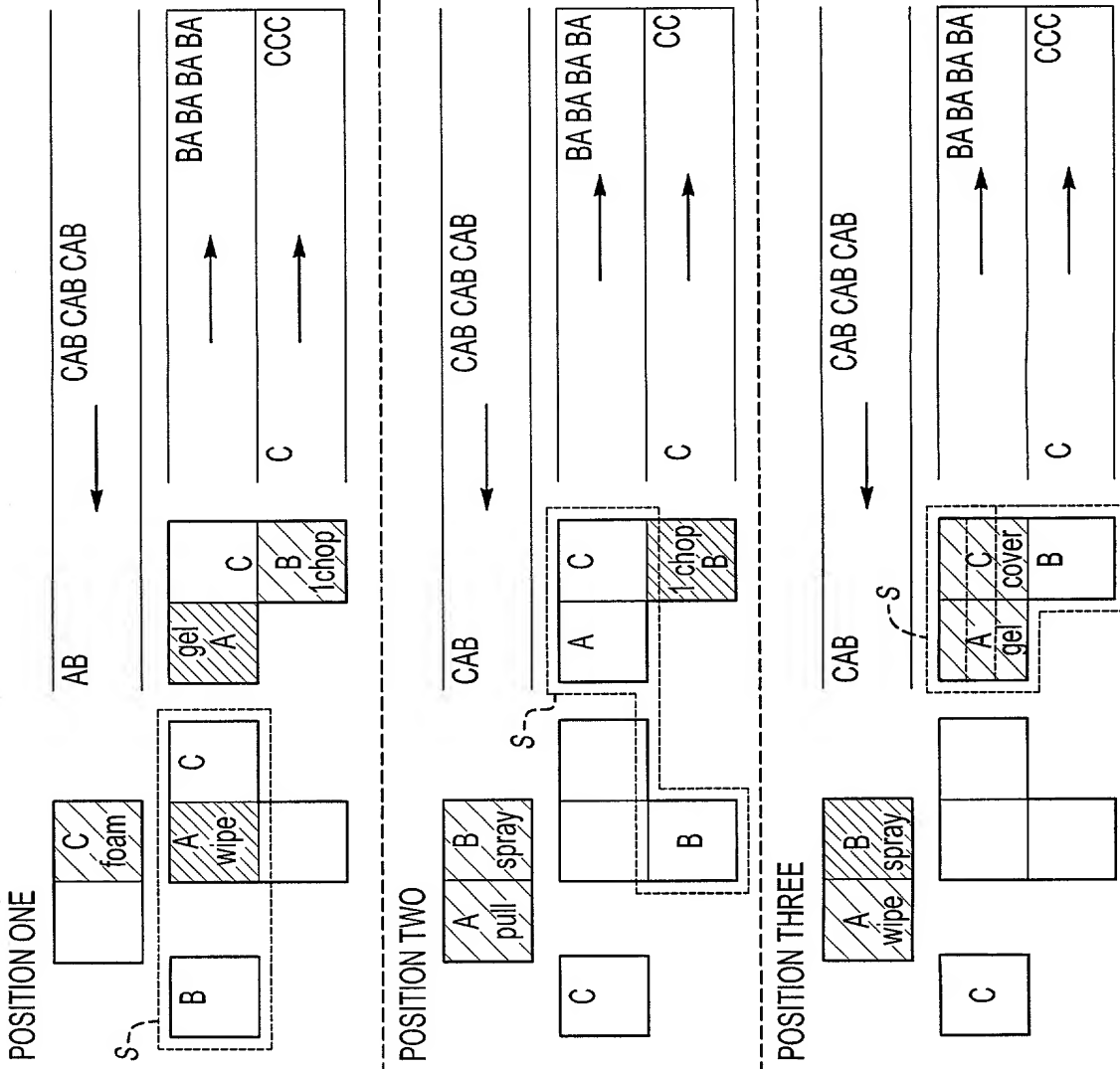
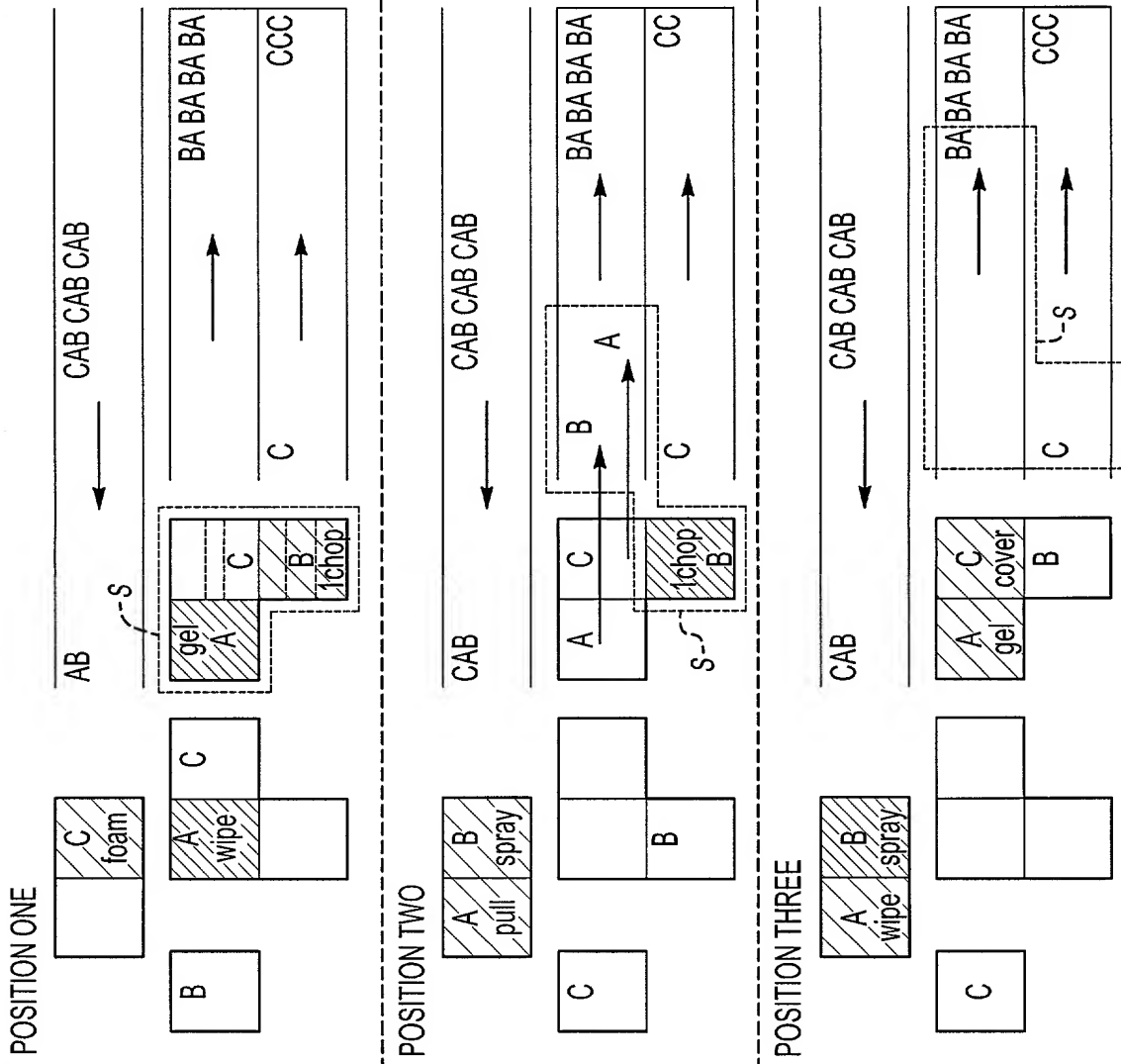


Fig-4C



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